User:

Wednesday, 22/10/2008 1:31:51 PM

Julie Dawson

#### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 42820 : 12712

**Estimate Number** P.O. Number

This Issue

: 22/10/2008

: NC

: 11 First Issue

Previous Run

Written By

Prsht Rev.

: 42351

Type

S.O. No.

: SMALL /MED FAB

**Drawing Number** 

Project Number **Drawing Revision** 

**Drawing Name** 

**Part Number** 

Material

: 04/11/2008 **Due Date** 

: WEARPAD

: D35371

: N/A

: D3537 REV C

Qty:

40 Um:

Each

Checked & Approved By Comment

: Est Rev:A

New Issue 07-02-14 JLM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

304/316 Sheet .063

M304S16GA

Comment: Qty.: 0.1113 sf(s)/Unit Total: M304S16GA .063" 304 SS SHEET

4.4520 sf(s)

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3537 Dwg Rev:

Prog Rev:\_\_\_\_

R 158-10-33

2-Deburr if necessary

H3 8-10-93

3.0

QC2

B 8-10-23

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1



## Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				В	Ву	Date Qt	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
			4	: }				,			4.
		•		1 1 2 1							

Part No:	D3537-1	PAR #: NA.	Fault Category: Prop - 5m /ned.	NCR Yes No DQA:	Date:	08.11.1
-	0 - 1 - 11	other	Dec: (20 0) 00 C	QA: N/C Closed:		Meluli

NCR: 4	2820	. <b>W</b> (	ORK OR	DER NON-CONFORMANC	E (NCR)	V		
DATE	STEP	Description of NC	Initial	Corrective Action Section B Action Description	Sign &	Verification	Approval	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	
•		Durking inspection it was found that the operator		use for D26483and				
6/10/23	2.6	of Stanlies Stell Char	क जिल्लासाय क	neplace on this workards	8-10-23	00/0/23	Posicis	००१७१३३
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NOTE: Date & initial all entries

Wadnesday, 22/10/2008 1:31:51 PM Date: Julie Dawson User: **Process Sheet** Drawing Name: WEARPAD Customer: CU-DAR001 Dart Helicopters Services Job Number: 42820 Part Number: D35371 Job Number: Seq. #: **Machine Or Operation:** Description: LARGE FAB 1 LARGE FABRICATION RESOURCE 1 6.0 Comment: LARGE FABRICATION RESOURCE 1 Qty Description M107213 x 21, M109 303 x19 2059B Hardcoat 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary VISUAL INSPECTION OF GROUND WELDS 7.0 QC10 Comment: VISUAL INSPECTION OF GROUND WELDS INSPECT WORK TO CURRENT STEP 8.0 Comment: INSPECT WORK TO CURRENT STEP 9.0 POWDER COATING Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE** 10.0 QC3 POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE #1 11.0 Comment: PACKAGING RESOURCE #1 Identify and Stock 12.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE mF 08-11-06 Job Completion

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W/O:			WORI	<b>CORDER CHANGES</b>				
DATE	STEP	PR	OCEDURE CHANG		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		V.3.						
**		•						
Part No	:	PAR #:	Fault Category	/:  No	CR: Yes	No DQA:	Date: _	
					QA: N/	C Closed:	Date: _	<del> </del>
NCR:		*	WORK ORDER	NON-CONFORMANC	E (NCR			
		Description of NC	Cor	rective Action Section B	<del></del>	Verification	A	Annaval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						7		
		4						
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NOTE: Date & initial all entries

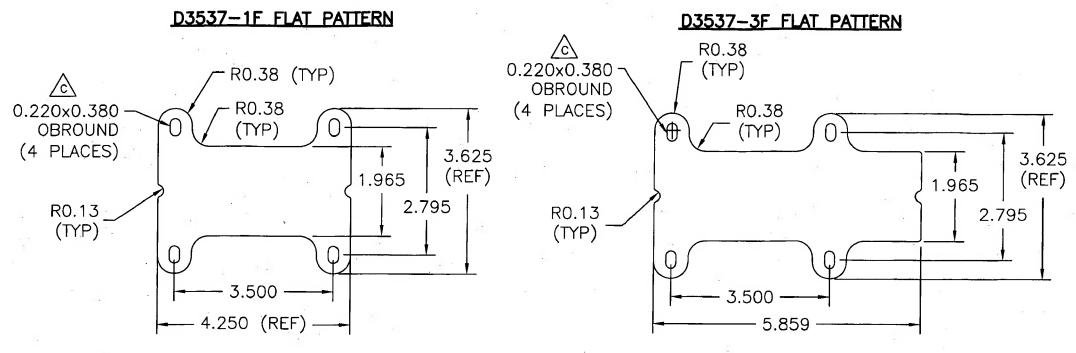
DART AEROSPACE LTD	Work Order: 42820		
Description: Wearpad	Part Number: D353	7-1	
Inspection Dwg: D3537 Rev: C	Page 1	of 1	

#### FIRST ARTICLE INSPECTION CHECKLIST

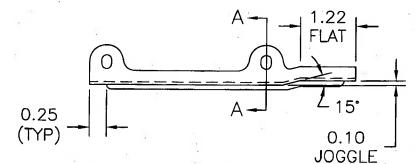
Drawing   Dimension   Actual   Dimension   Accept   Reject   Method of Inspection   Comments		_ ;	First Art	icle	Prot	otype		
3.500 +/-0.010 3,500 %  1.965 +/-0.010 1.966 %  2.795 +/-0.010 3.626 %  0.220 x 0.380 +/-0.010 205 x 3% %		Tolerance		Accept	Reject		Comr	nents
3.500 +/-0.010 3.500 x  1.965 +/-0.010 [.966 x  2.795 +/-0.010 3.630 x  0.220 x 0.380 +/-0.010 3.630 x  1.966 x	4.250	+/-0.010	4.250	æ .	e r			
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2.795	1.965	+/-0.010			_	1		
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0.220 x 0.380 +/-0.010 >>5 X 3% ×	3.625	+/-0.010		<b>X</b>				
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leasured by: Audited by: Prototype Approval: N				<u> </u>				N/A

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 8-10-2	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM	
В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
С	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	Gal

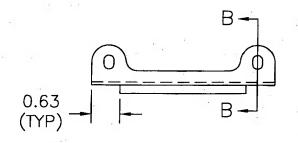






# D3537—3 LONGITUDINAL BEND (MADE FROM D3537—3F)





### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004

0.25

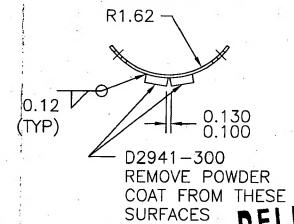
(TYP)

- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



0.25

(TYP) †



SECTION A-A

APPLY 2 LAYERS OF

TO WITHIN 0.25 OF

WEARPAD ENDS

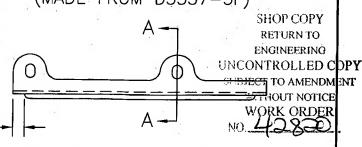
2059B HARDCOAT WELDS

0.188 TO 0.250 THICK

R1.62 -

D3537-7 LONGITUDINAL BEND 962

(MADE FROM D3537-3F)



	CHECK	KED 🔏	APPROVED	DRAWING NO. REV. C
4	DESIG	CB	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
	Α		06.11.06	NEW ISSUE
	В		07.03.20	ADD AMS 5513 AND AMS 5524
	С		07.04.13	WIDEN TAB TO 0.380, WELD PATTERN

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CHECKED APPROVED DRAWING NO. PORT HADLOCK, WA REV. C D3537 SHEET 1 OF 1

DATE TITLE SCALE

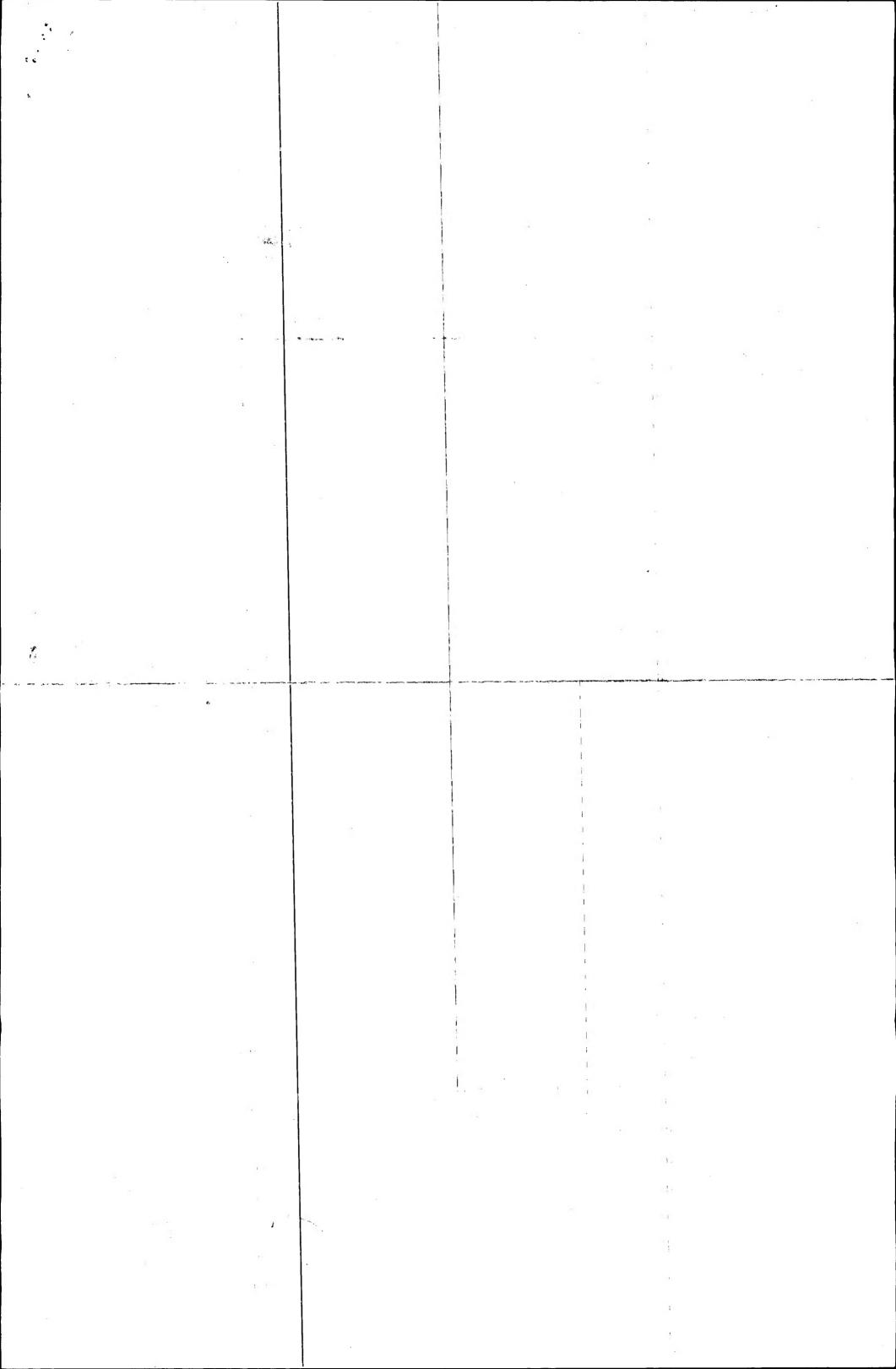
O7.04.13

DART AEROSPACE USA, INC. PORT HADLOCK, WA

REV. C D3537

SHEET 1 OF 1

1:2



DART AEROSPACE LTD			Work Order:	42820
	an			
Description:		-A <sub>2</sub>	Part Number:	5 3537-1
Inspection Dwg: D3537-1 , Rev:				Page 1 of 1

spection Dwg:	,	**		<del></del>		Page 1 of 1
. **	FIRST	First Artic		_	•	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
4.250	4010	4.249	×			
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1.965	4010	1.968	×			
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easured by:	,	Audited by:	KII	Pro	ototype Appro	val:
Date:	8-10-27		08/0/29			ate: A

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	